

Date: Tuesday, 15/07/2008 9:13:13 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 40467		
Estimate Number	: 10710		
P.O. Number	:	Part Number	: D32111
This Issue	: 15/07/2008 S.O. No. :	Drawing Number	: D3211 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 39743	Material	:
Written By	:	Due Date	: 21/07/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JLD 08.15.08</u>		
Comment	: Est Rev:A New Issue 05-11-17 JLM		
	: Est Rev:B Now on Waterjet 06-10-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.4753 sf(s)/Unit Total: 14.7525 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063) Identify as D3211-1
 Batch: 108415 HB 8-8-11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3211
 Dwg Rev: A1
 Prog Rev: A1

HB 8-8-11

(10)

2-Deburr if necessary HB 8-8-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-8-11



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/08/11 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

n/a Done at step #2.2
8/8/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:13:13 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40467

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



PTO

Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

86 08/09/19 (3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/09/20 (3)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(3X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/09/22

9.0

POWDER COATING

POWDER COATING



(3X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320 °F
11:00

M-L 08/09/24

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-24 (X3)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST212

88 08/09/24 (X3)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/25


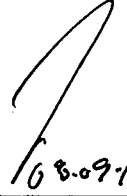



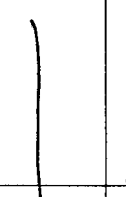
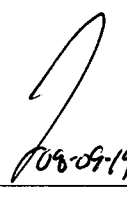
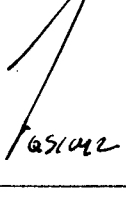
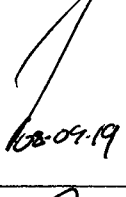



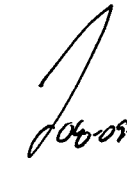

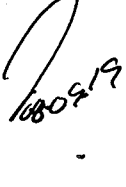
Job Completion



4 0809.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3211-1 PAR #: NA Fault Category: Prod / AS ^{red & small} NCR: Yes No DQA: D Date: 08/01/06
 Eng/Dwg. QA: N/C Closed: D Date: 08/09/06

NCR: 40467		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/19	6	7 piece were scrap piece broke at the bend R.C material were		Scrap & destroy No replace	JP 08/09/19			
		Drawing wasn't change for 45°		Drawing is being updated.				
		Took die 3/16 until 118 grain ran along the bend.						

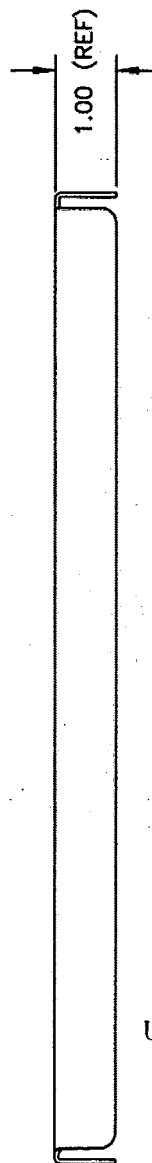
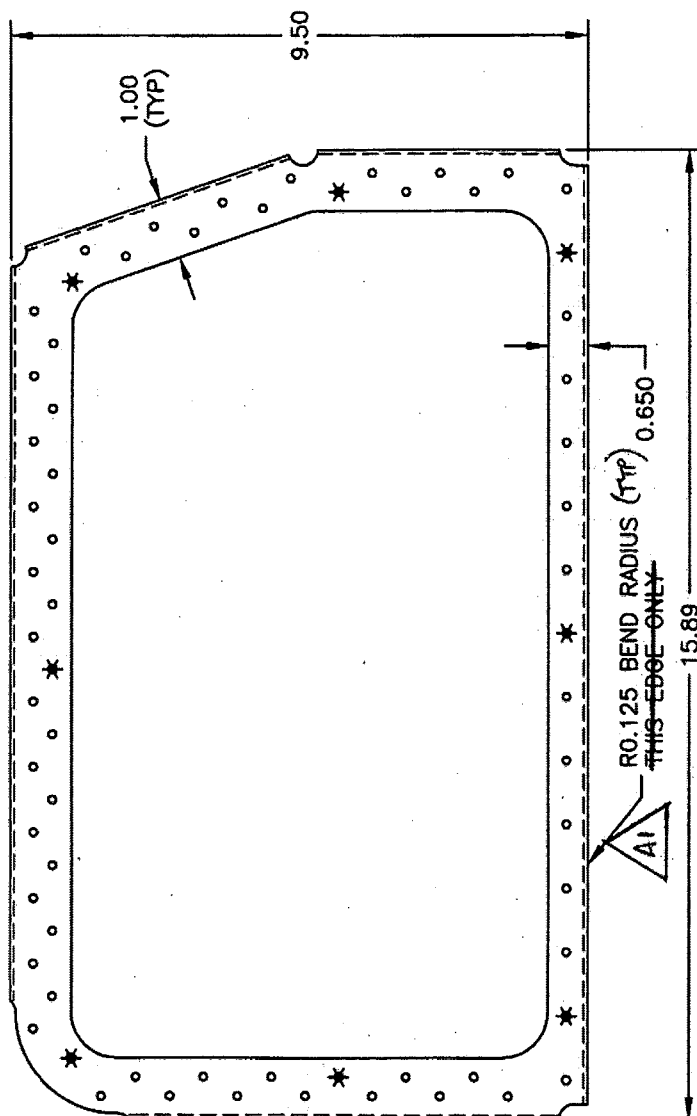
NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO. D3211	SHEET 1 OF 2
DATE	03.09.03	TITLE	BRACKET	SCALE	1:3
A	03.09.03	NEW ISSUE			
A1	[Signature] 03.12.05	CHANGE ALL BEND RADII TO R0.125			

RELEASED
03.09.15

D3211-1 BRACKET
MACHINE PER DRAWING FILE "D3211-A2.DWG"
CHECK PER TEMPLATE D3211-1T1
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
USE MINIMUM BEND RADIUS OF ~~0.188"~~ **0.125"** EXCEPT WHERE INDICATED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED







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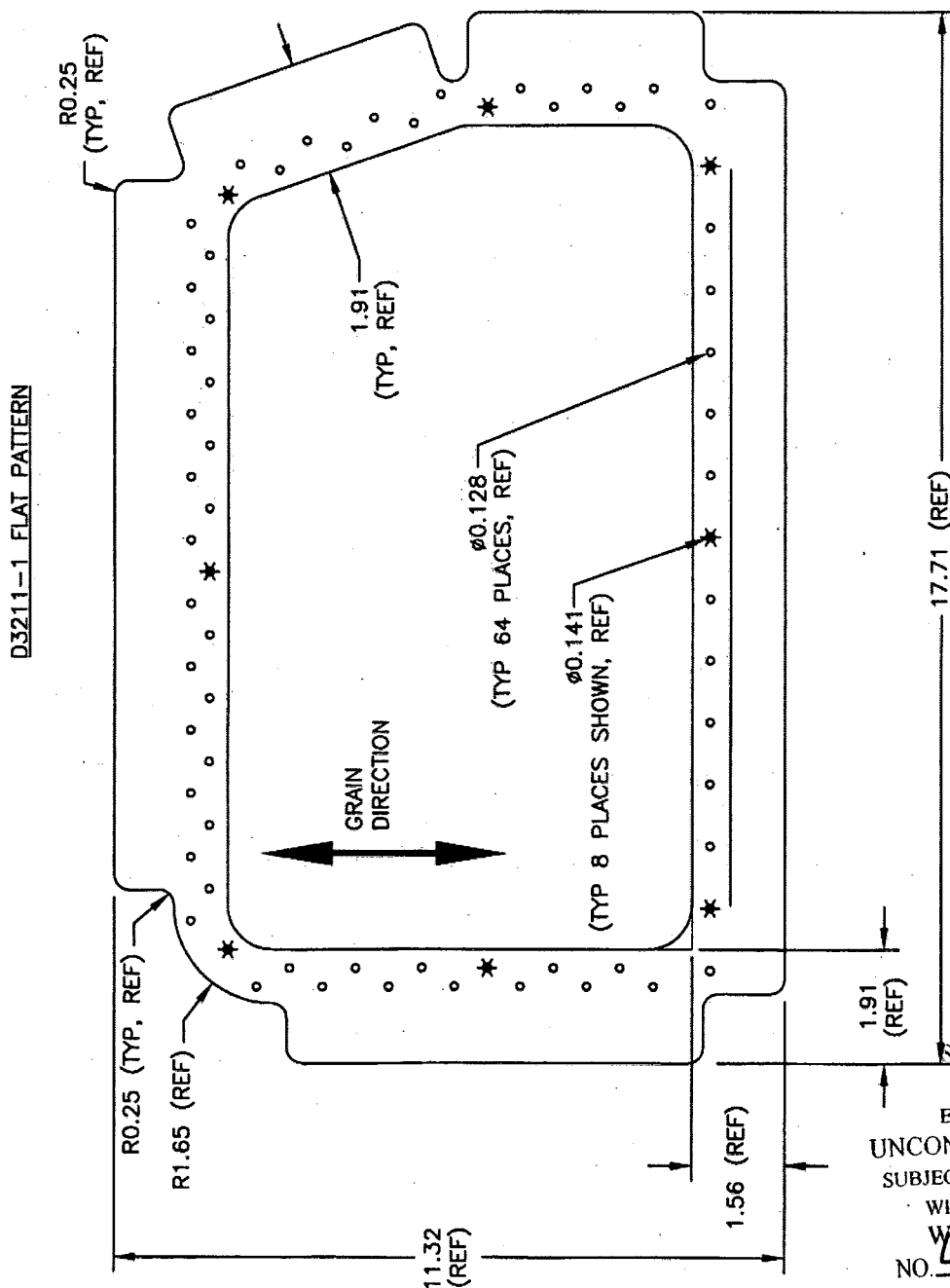
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CHECKED 	APPROVED 	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3

RELEASED
03 09 15



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